

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

1. (original) Method for producing a multi-ply web of flexible material, at a plurality of glue sites, which comprises:

by gluing the plies bringing a patterned glue transfer roll, having a pattern of protuberances, in contact with a glue application device;

transferring glue to a first web shaped flexible material in a glue pattern corresponding to the configuration of the protuberances;

bringing a second web shaped flexible material in contact with the glue applied side of said first web shaped flexible material in a press nip between a patterned lamination roll and an impression roll; said lamination roll having a pattern of protuberances corresponding to said glue pattern; the glue transfer roll and the lamination roll being in register with each other, so that the first and second web shaped flexible materials are combined and glued together in a pattern corresponding to the configuration of the protuberances of the glue transfer roll, wherein the first web shaped flexible material and/or the second web shaped flexible material is printed by a printing roll carrying a colorant in a selected pattern; and said printing is

performed in register with the glue transfer while the first and/or second web shaped flexible materials are residing on said impression roll.

2. (original) Method as claimed in claim 1, wherein said first web shaped flexible material is printed before it is laminated to the second web shaped flexible material, and the printed pattern is printed on the inner side of the first web shaped flexible material facing the second web shaped flexible material.

3. (original) Method as claimed in claim 2, wherein two or more patterns are printed in subsequent steps on said first web shaped flexible material before it is laminated to the second web shaped flexible material, said patterns being printed in register with each other and with the glue pattern.

4. (original) Method as claimed in claim 1, wherein said second web shaped flexible material is printed after or simultaneously with the lamination to the first web shaped flexible material, wherein the printed pattern is printed on the outside of the second web shaped flexible material.

5. (original) Method as claimed in claim 4, wherein two or more patterns are printed in subsequent steps on said second web shaped flexible material after or simultaneously with the lamination to the first web shaped flexible material, said patterns being printed in register with each other and with the glue pattern.

6. (original) Method as claimed in claim 2, wherein at least two printing stations are provided; at least one first printing station prints at least one first pattern on the first web shaped flexible material before it is laminated to the second web shaped flexible material; and at least one second printing station prints at least one second pattern on the second web shaped flexible material after lamination to the first web shaped flexible material.

7. (original) Method as claimed in claim 1, wherein the glue is a coloured glue, and a coloured glue pattern will appear as a printed pattern.

8. (original) Method as claimed in claim 7, wherein a printing pattern is the same as and printed on the next web shaped flexible material just on top of a coloured glue pattern on the underlying web.

9. (original) Method as claimed in claim 8, wherein said printing pattern and said glue pattern are of different colour.

10. (original) Method as claimed in claim 6, wherein the two printing patterns are different.

11. (original) Method as claimed in claim 7, wherein the coloured glue pattern and the printing pattern are different.

12. (original) Method as claimed in claim 1, wherein the size of each glue site amounts to between 0.15 and 150 mm².

13. (original) Method as claimed in claim 1, wherein the number of glue sites per unit area amounts to between 25 per m² to 150 per cm².

14. (original) Method as claimed in claim 1, wherein the pattern configuration of the glue transfer roll is chosen so that glue is applied to said first ply in glue sites covering an area corresponding to between 0.03 and 9% of the total area of the first web shaped flexible material and sparsely distributed over substantially the entire area of the first web shaped flexible material.

15. (original) Method as claimed in claim 1, wherein at least one of the plies before lamination with the opposite ply is exerted to a three dimensional patterning provided on the ply while wet, during drying of the wet ply and/or in dry state.

16. (original) Method as claimed in claim 1, wherein the multi-ply web after lamination is embossed.

17. (original) Method as claimed in claim 1, wherein any of said web shaped flexible materials comprises one or more plies of flexible material.

18-32. (cancelled)